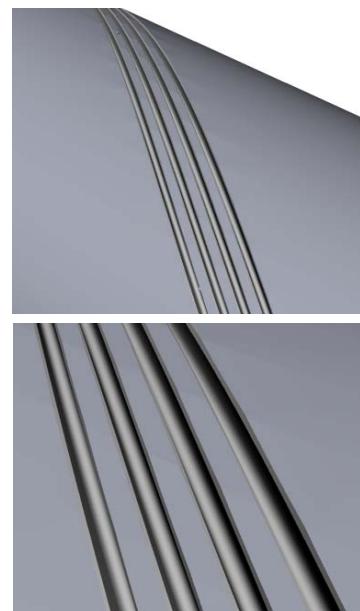
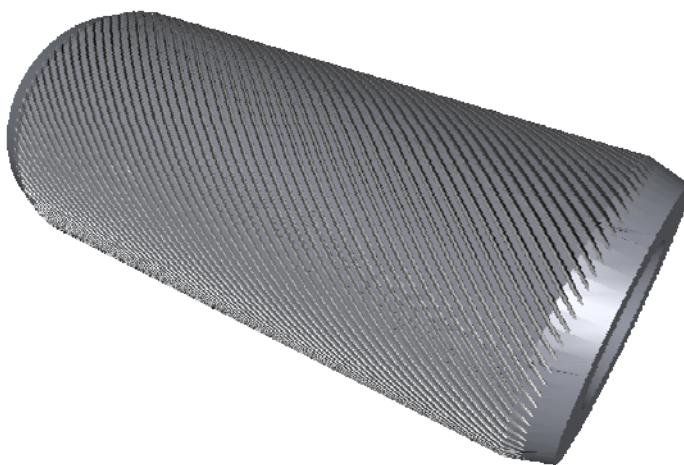


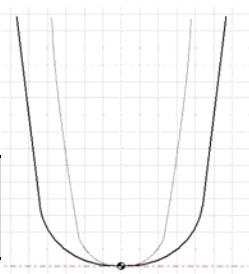
Grooving Plug Ø8.2 L17 Z80

A30-010



1. Cycletime for Production

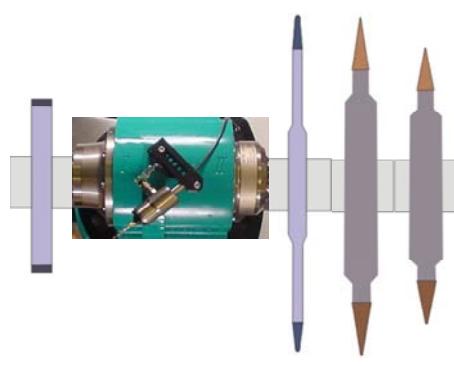
Workpiece: Ø8.2 L17 ID4.0 Material HSS	Chamfers: cyl. grinding oscillating grooves: 1 pass rough, 6 passes finish grooves chamfers: 1 pass
Operations	 Chamfers  Groove Rough  Groove Finish  Groove Chamf.
Feed [mm/Min]	150 120 500 300
Power [kW]	1 1 1 1
Cutting speed [m/s]	32 32 32 32
Used wheels	 1  2  3  4
Grinding time [s]	272 1028 1729 444
Total cycle time	57 Min 53



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 B54
2	14EE1 Ø125 B46V90°
3	14EE1 Ø150 B46V12°
4	14EE1 Ø150 B25V12°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA, NGC

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories:

Responsible engineer: OP, 22.9.14

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY
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